

Date: Monday, 3/17/2008 11:57:15 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT CROSSTUBE
 Job Number : 38039
 Estimate Number : 10377
 P.O. Number :
 This Issue : 3/17/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2890
 First Issue : / / Type : PURCHASED PARTS Drawing Number : D2890 REV B
 Previous Run : 36621 Drawing Revision : B
 Material :
 Due Date : 4/4/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 08 03 17
 Comment : Est. D 05.03.21 Removed Bending procedures KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6008180 Crosstube extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part #	Description	Batch
1	D6008-180	Crosstube extrusion	R 23964

DP 8-3-28

2.0 BENDING BENDING MACHINE



Comment: BENDING MACHINE

1-Bend D2890 as per Dwg D2890 and Folio FT002

DP 8-3-28

3.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr and Polish

N/A

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005.4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/17/2008 11:57:15 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CROSSTUBE

Job Number: 38039

Part Number: D2890

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

SOR WA 37549 (-107) 080331 ①

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U. 08-03-31

08/04/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

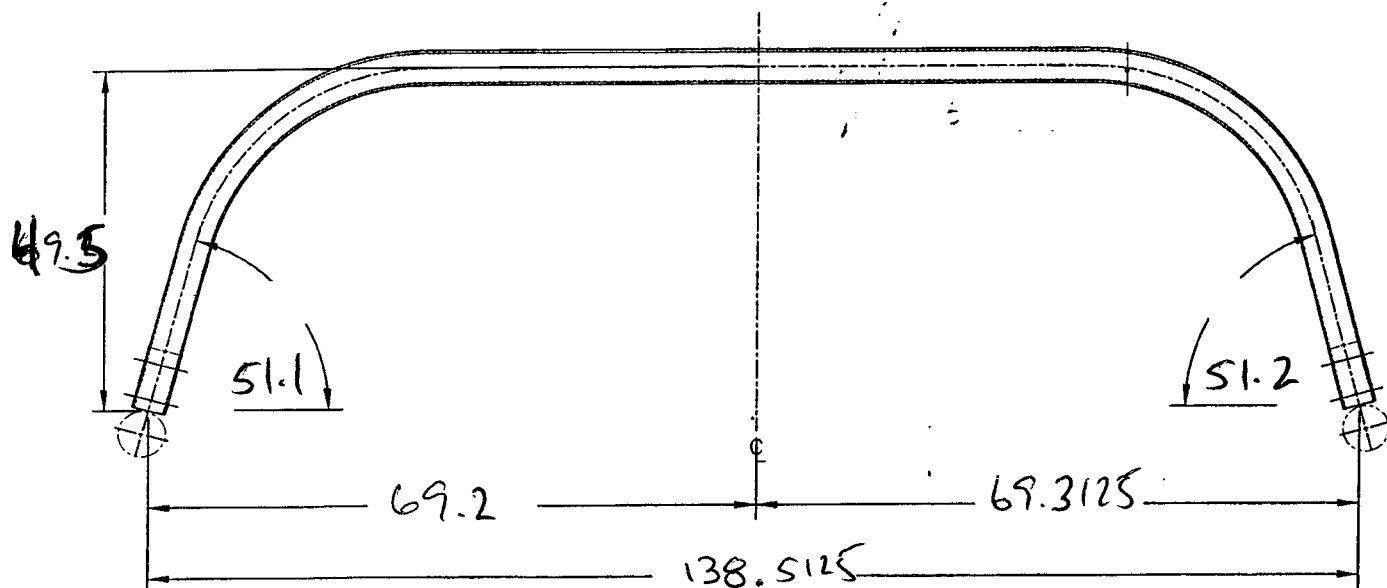
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	38039
Description: Crosstube Aft		Part Number:	D2890
Inspection Dwg: D2890		Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments
Tube is good for A -107 see w/o.

QC15 Inspection	25/11/2
Date	08-03-31

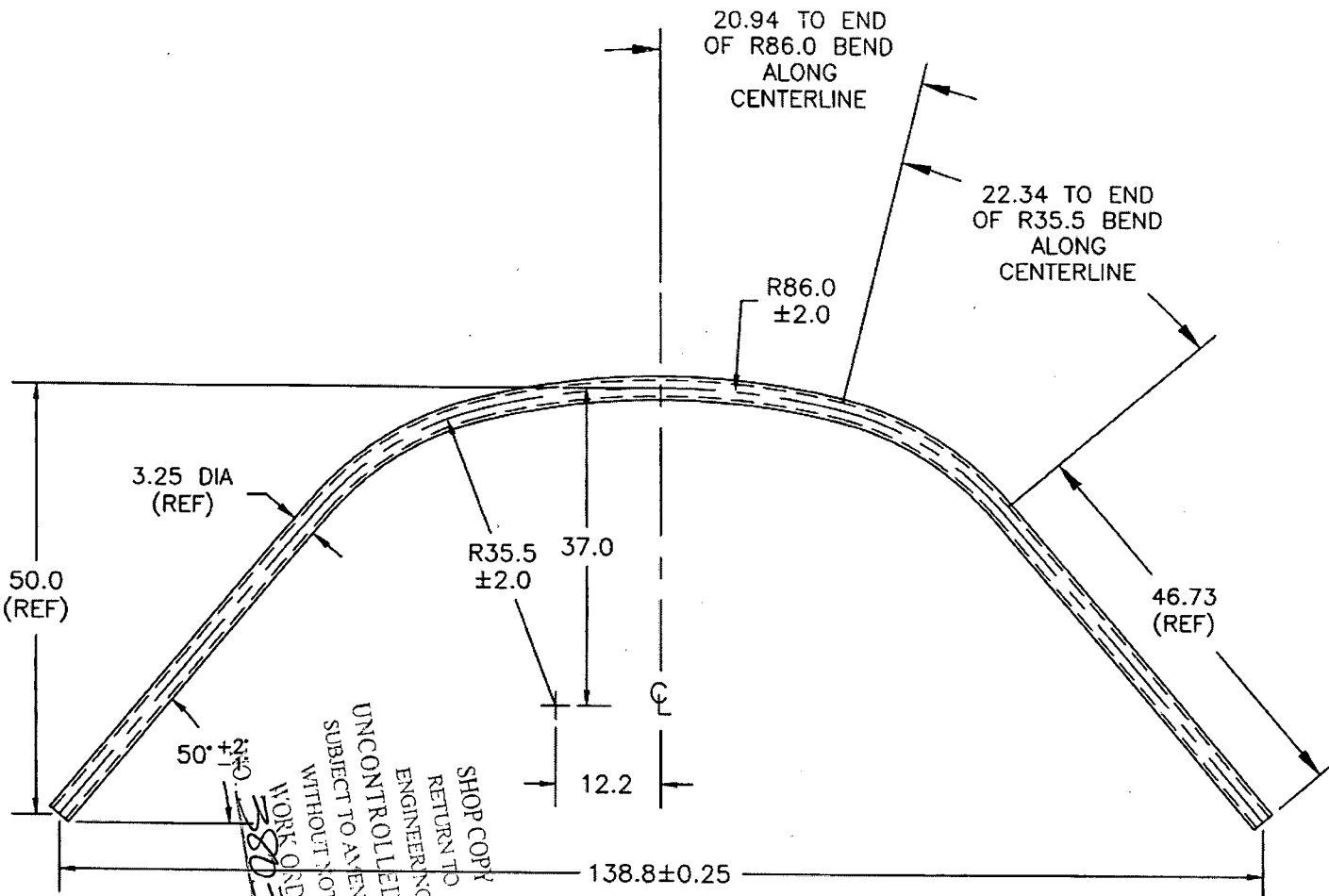
Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	[Signature]

DART



RELEASED
02.10.28

DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED		APPROVED		DRAWING NO.	
DATE		TITLE		REV. B	
02.10.18		AFT CROSSTUBE		SHEET 1 OF 1	
A		99.05.21		SCALE	
B		02.10.18		ADD TANGENT LENGTHS; CHANGE NOTES	



NOTES

- 1) MATERIAL: MANUFACTURE FROM D6008-180 (ø3.25 OD x 0.438 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.